

Work Order ID 165559

165559

Page 1

Monday, August 28, 2017 11:40:32 AM

Item ID: D4716-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Duct Hose
 Start Date: 8/29/2017 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 9/13/2017 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: AUG 29 2017 Tooling: Date: Run Start *NR1*
 QC: 9-89 Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4716	A								

100 0.00
 100
 Purchasing
 Purchasing
 Memo
 Issue P/O: 37617
 MANUFACTURE AS PER DWG D4716
 Supplier: CUSTOM DUCTS
 Certificate of conformity is required
4 DAS 13 9-89 P.O.B.
 AUG 30 2017

110 Receive & Inspect for Damage & Mat'l Certs 0.00
 110
 Packaging
 Packaging
 Memo
4x SPT-9-19.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Work Order ID 165559***165559***

Page 2

Monday, August 28, 2017 11:40:32 AM

Item ID: D4716-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Duct Hose

Start Date: 8/29/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 9/13/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- All purchased or subcontracted products

0.00

120

QC

Memo

0.00

Quality Control

(4) 17.09.20 PD

130

Identify as per dwg & Stock Location:

0.00

130

Packaging

Memo

0.04

Packaging

X 8-28-17 SEP 20 2017

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.40

Quality Control

17/9/21 2017
SEP 20 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

Monday, August 28, 2017 11:40:35 AM

Page 1

Work Order ID: 165559

165559

Parent Item: D4716-1

D4716-1

Parent Item Name: Duct Hose

Start Date: 8/29/2017

Required Date: 9/13/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.11.08 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4716-1P		Purchased	No			110	Each	0.0000	1	4			
D4716-1P									**				
Duct Hose													

4x SP17-9-19.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

- NOTES:
- 1) MATERIAL: PER TABLE
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: PER TABLE

REV	DESCRIPTION	DATE
A	NEW ISSUE	12.07.25
DESIGN	RF	RF
DRAWN	RF	RF
CHECKED	RF	RF
MFG. APPR.	RF	RF
APPROVED	RF	RF
DE APPR.	RF	RF
DATE	12.07.25	

DART AEROSPACE LTD
HAMMERSBURY, ONTARIO, CANADA

DRAWING NO. **D4716**

TITLE **DUCT HOSE**

SCALE **NTS**

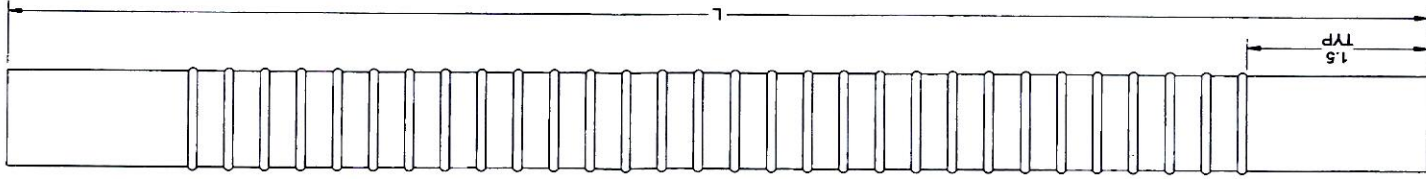
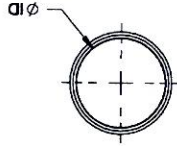
SHEET 1 OF 1

REV. A

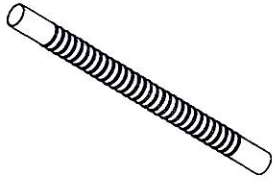
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D4716-X DUCT HOSE

DART PART NUMBER	DESCRIPTION	POSSIBLE VENDOR	VENDOR PART NUMBER	MATERIAL	ID	WEIGHT (lb)
D4716-5	DUCT HOSE	CUSTOM DUCTS		SILICONE RUBBER	0.75	41.0
D4716-3	DUCT HOSE	CUSTOM DUCTS		SILICONE RUBBER	0.75	28.0
D4716-1	DUCT HOSE	CUSTOM DUCTS		SILICONE RUBBER	0.75	24.0
						0.2
						0.2
						0.3



SPECIFICATION CONTROL DRAWING



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 16555 M.S
170829



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37617**

Purchase Order Date 8/30/2017

PO Print Date 8/30/2017

Page Number 1 of 2

Order From :
CUSTOM DUCT
179 BEAVER BERRY ROAD
LIMINGTON, MAINE 04049

VU-CD001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

AUG 31 2017

Contact Name
Vendor Phone 207-637-3000

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

Buyer Diane Baker
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency USD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	D4716-1P	Duct Hose	9/12/2017 Yes 9/12/2017		4.00 Each	\$30.00	\$120.00
	As per Dwg D4716 Rev. A B165559						
						Line Total:	\$120.00
2	D4716-3P	Duct Hose	9/12/2017 Yes 9/12/2017		4.00 Each	\$34.00	\$136.00
	As per Dwg D4716 Rev. A B165585						
						Line Total:	\$136.00
3	D4716-5P	Duct Hose	9/12/2017 Yes 9/12/2017		12.00 Each	\$38.00	\$456.00
	As Per Dwg D4716 Rev. A B165718						

Note:

8/30/2017

Custom Duct

179 Beaver Berry Rd
Limington, ME 04049
PH 1 800 863 2620

Invoice

Date	Invoice #
9/14/2017	2075

Bill To
Dart Aerospace 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Ship To
Dart Aerospace 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

P.O. Number	Terms	Rep	Ship	Via	F.O.B.	Project
PO037617	Net 30		9/14/2017	Federal Express		
Quantity	Item Code	Description			Price Each	Amount
12	SCEET	Double Wall SCEET 3 X 41" Your D4716-5P			38.00	456.00
4	SCEET	Double Wall SCEET 3 X 28" Your D4716-3P			34.00	136.00
4	SCEET	Double Wall SCEET 3 X 24" Your D4716-1P ✓			30.00	120.00
	Ship	Shipping Charge Fedex collect			0.00	0.00
SP179-19.						
Phone #		Fax #		E-mail		Total \$712.00
207 637 3000		207 637 3000		kinney@fairpoint.net		

Custom Duct
179 Beaver Berry Rd.
Limington, ME 04049

CERTIFICATE OF CONFORMANCE

Customer Name: Dart Aerospace Ltd. Purchase Order No: PO37617

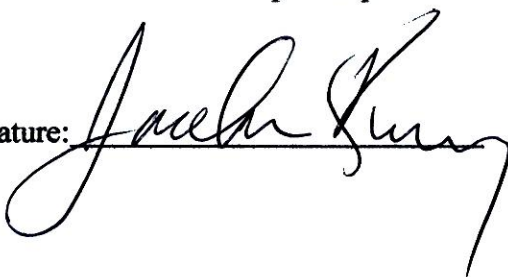
✓ 4 EACH SCEET 3 X 24" Your D4716-1P WITH CUFFS

12 EACH SCEET 3 X 41" Your D4716-5P WITH CUFFS

4 EACH SCEET 3 X 28" Your D4716-3P WITH CUFFS

This is to certify that the products, systems and/or services listed here-in have been manufactured, inspected and tested in accordance with Custom Duct and industry standards. It is further certified that the items listed here-on are in compliance with the provisions of your purchase order/ work order listed above. Inspection and test records and material certifications are on file and available upon request.

Signature:



Date: 14 September 2017